

Work Order ID 68010

Tuesday, April 05, 2011 10:53:48 AM



Page 1

Item ID: D4323-25
Revision ID: PRELIM
Item Name: Panel, Glove Box

Accept



Setup Start



Stop



Start Date: 4/5/2011 Start Qty: 1.00
Required Date: 4/5/2011 Req'd Qty: 1.00



Cust Item ID:
Customer:

~~PRELIMINARY ISSUE~~

Reference:

Approvals: Process Plan: *MF* Date: *11-04-05* Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4323	<i>PA7 PA6 Plu 11/04/05 A</i>	0.00							

100		0.00							
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1-Cut Sheet to required Blank size								

105		0.00							
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Dry Sheet as per QS1022 Kydex								

Temp: *150°*
Time IN: *6:00 PM 11/04/05*
Time OUT: *7:00 AM 11/04/05*

1 *BB*
11/04/05

1 *BB*
11/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start



Stop



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110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA109 using tool DT9734

Dwg Rev: PASFolio Rev: A

1

BB
11/04/05

120

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Visually inspect part for proper formation and texture

1

BB
11/04/05

130

0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

1

BB
11/04/05

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg					1			OK n/04/05
150 QC	QC2- Inspect parts off machine FAI/FAIB	0.00							
Quality Control	Memo	0.00							
	Complete FAI document								BB 11/04/05
160 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
									- inspect to P47 Dm only Sulovlor (XP)

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Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <i>REAG</i>	0.00							
	Packaging	Memo							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
	QC	Memo							
Quality Control									

4/4/11

11/5/16

RD2370

POSITIVE RECALL

EFFECTIVE *11-04-05*

RELEASED *WFO*

AUTH *u*

DATE *11/05/13*

MF 11-04-06

Picklist Print

Tuesday, April 05, 2011 10:53:46 AM

Page 1

Work Order ID: 68010



Parent Item: D4323-25



Parent Item Name: Panel, Glove Box

Start Date: 4/5/2011

Required Date: 4/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA New Issue 11-03-01 DL verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	787.2912	3.46875	3.46875			



6185 KYDEX .080"



Location

Loc Qty

Loc Code

therm

787.2912

787.2912

116576

3.46875 sf

11/04/06

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DART AEROSPACE LTD	Work Order: 68010
Description: PAPEL GLOVE BOX	Part Number: D4323-25
Inspection Dwg: 4323-25 Rev: PA8	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>JB</u>	Date: 11/04/05
-------------------------------	-----------------------

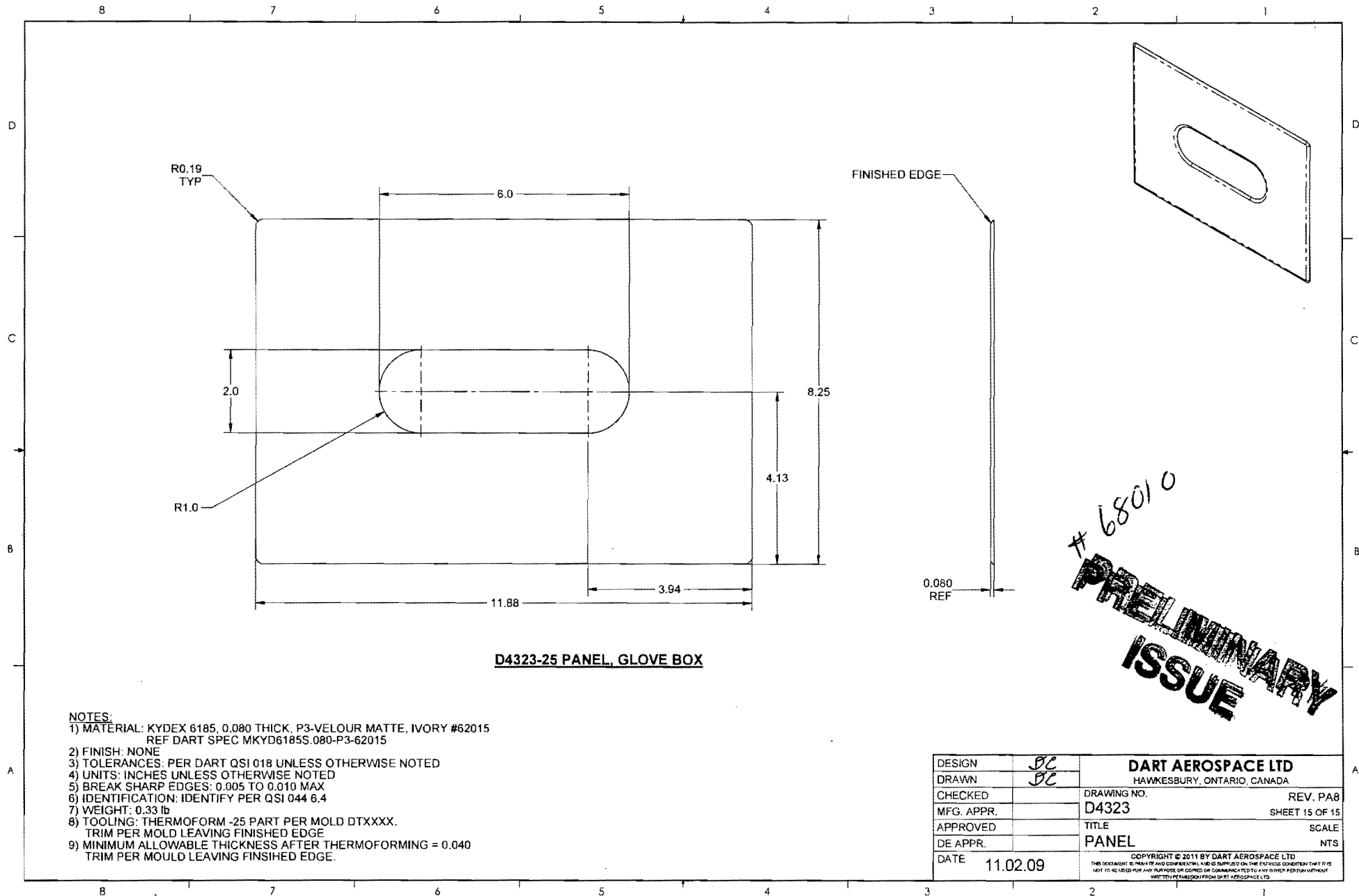
TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
11.88	± .030	11.8	✓		HH-05	
8.25	± .030	8.187	✓		HH-05	
6.0	± .006	6.0	✓		HH-01	
2.0	± .100	2.0			HH-01	

Measured by: <u>JB</u>	Date: 11/04/05
Audited by: <u>E to Part Dwg only</u>	Date: 11/04/06
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14



Daryl Leger

From: Daniel Campbell <dcampbell@dartaero.com>
Sent: Saturday, April 02, 2011 5:44 PM
To: 'Daryl Leger'
Cc: 'Eric Charbonneau'; 'JEANLUC MENARD'; 'Linda Lacelle'; Bill Beckett; 'Harvey Siemens';
'David Shepherd'
Subject: D4380 Issues

Hi Daryl,

Please see D4380-PA6 in the Prelim folder.

Fortunately, the guys were still here and I talked to them about the manufacturing issues.

Based on their feedback, I have modified the D4380-17 cover. It should be a little easier to manufacture.

However, the -3/-5/-27/-29 need to stay as they are. Please use the "cheat the corners" technique to make the part as true to the drawing as possible. There are spare air conditioning vents here – we could fedex you one on Monday if that would help in creating the moulds.

The only thing I changed in the PA6 rev was the -17.

As for cutting out the "tops" of the round parts (-21/-23/-25 etc), it is up to you. If you would like to cut it out and trim it, that's ok, or the guys here can do that.

Thanks Daryl,

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

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R0.19
TYP

6.0

FINISHED EDGE

2.0

8.25

R1.0

4.13

11.88

3.94

0.080
REF

68010

D4323-25 PANEL, GLOVE BOX

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.33 lb
- 8) TOOLING: THERMOFORM PER MOULD DT9734 AND DART QSI 022
- 9) TRIM PER MOULD LEAVING FINISHED EDGE
- 10) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040

RELEASED
2011-05-10
MD

DESIGN	DL	DART AEROSPACE LTD	
DRAWN	DL	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DL	DRAWING NO.	REV. A
MFG. APPR.	DL	D4323	SHEET 15 OF 15
APPROVED	DL	TITLE	SCALE
DE APPR.	DL	PANEL	NTS
DATE	11.04.21	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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